

Date: Thursday, 02/04/2009 2:29:02 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MAIN PANEL
Job Number :	46892		
Estimate Number :	13164		
P.O. Number :		Part Number :	D37051
This Issue :	02/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3705 REV.C
First Issue :	//	Project Number :	N/A
Previous Run :	46284	Drawing Revision :	C
		Material :	
Written By :		Due Date :	17/04/2009
Checked & Approved By :	JUD 09-04-03	Qty:	4 Um: Each
Comment :	Est Rev:A 08-01-30 new issue EC verified by:DD Est Rev:B 09-01-09 rev.C prelim as per dwg DD verified by:EC Est Rev:C 09-02-20 rev.c as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 2.1651 sf(s)/Unit Total : 8.6604 sf(s)
 6061T6 aluminium sheet .080" thick
 (M6061T6S080)
 Batch: 110630 B 9-4-24

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3705
 Dwg Rev: C 189-4-24
 Prog Rev: C
 grain direction along 21.97*
 2- Deburr if necessary 189-4-24



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5 09/04/24 (x6)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-COUNTER SINK AS PER DWG
 2- BEND AS PER DWG D3705

EB 09/05/05 (6)
SB 09/05/25



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:29:02 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN PANEL

Job Number: 46892

Part Number: D37051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/25 (16)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ~~20~~ CARL

9/5/27

SLP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/27 HJ

Job Completion



MF
09-05-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46892
Description: MAIN PANEL		Part Number: D3705-1
Inspection Dwg: D3705-1 Rev: C		Page 1 of 22

FIRST ARTICLE INSPECTION CHECKLIST

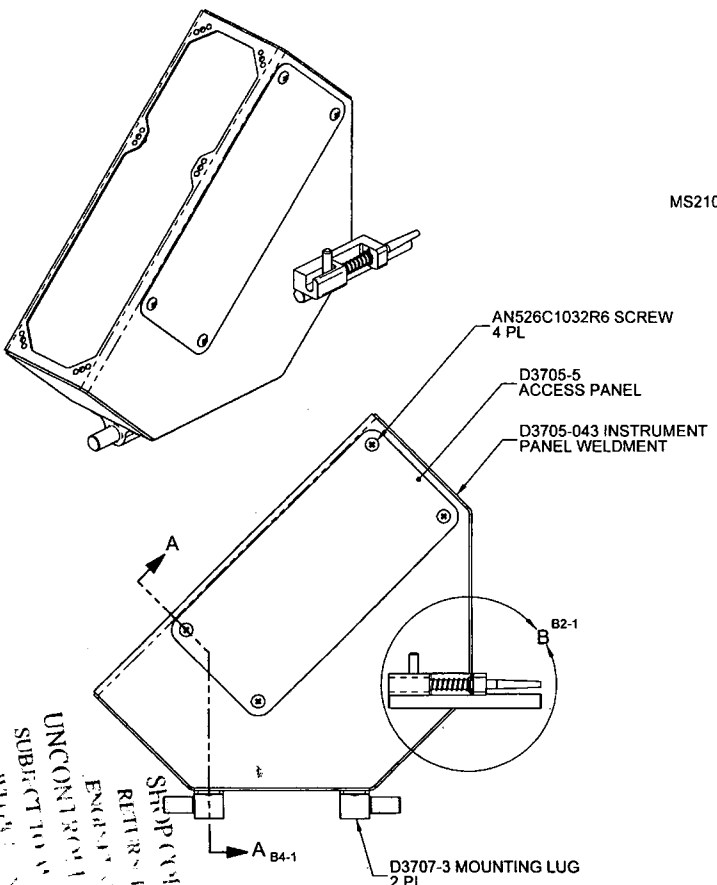
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.1101	✓			
Ø .261	+ .005 - .001	.263	✓			
.375	+/- .010	.377	✓			
.573	+/- .010	.571	✓			
1.18	+/- .030	1.181	✓			
4.00	+/- .030	4.004	✓			
4.375	+/- .010	4.375	✓			
7.89	+/- .030	7.891	✓			
8.31	+/- .030	8.312	✓			
8.625	+/- .010	8.626	✓			
8.94	+/- .030	8.942	✓			
9.125	+/- .010	9.128	✓			
9.36	+/- .030	9.368	✓			
12.50	+/- .030	12.50	✓			
12.927	+/- .010	12.907	✓			
13.125	+/- .010	13.125	✓			
13.50	+/- .030	13.50	✓			
4.375	+/- .010	4.375	✓			
9.31	+/- .030	9.317	✓			
9.560	+/- .010	9.566	✓			
10.11	+/- .030	10.113	✓			
11.86	+/- .030	11.866	✓			
12.414	+/- .010	12.414				

Measured by: JB	Audited by: S	Prototype Approval: a/
Date: 9-4-24	Date: 09/04/24	Date: 1/9

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

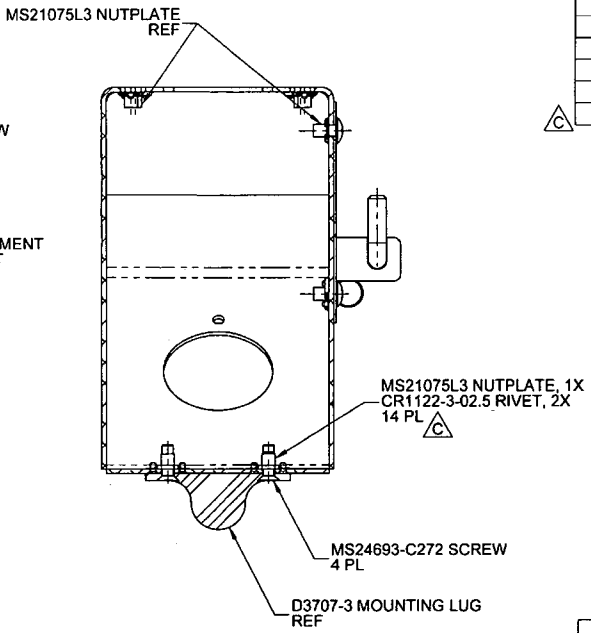
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D3705-041 INSTRUMENT PANEL ASS'Y

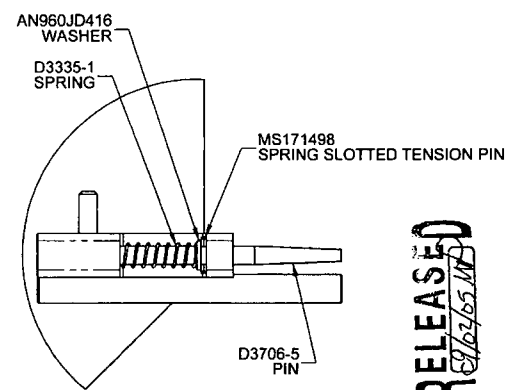
D3705-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-041" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.97 LBS



SECTION A-A
SCALE 2X

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3705-041	INSTRUMENT PANEL ASS'Y
5	1	D3335-1	SPRING
6	1	D3705-043	INSTRUMENT PANEL WELDMENT
7	1	D3705-5	ACCESS PANEL
8	1	D3706-5	PIN
9	2	D3707-3	MOUNTING LUG
13	4	AN526C1032R6	SCREW
14	1	AN960JD416	WASHER
15	1	MS171498	SPRING SLOTTED TENSION PIN
17	14	MS21075L3	NUT PLATE
18	4	MS24693C272	SCREW
19	28	CR1122-3-02.5	RIVET

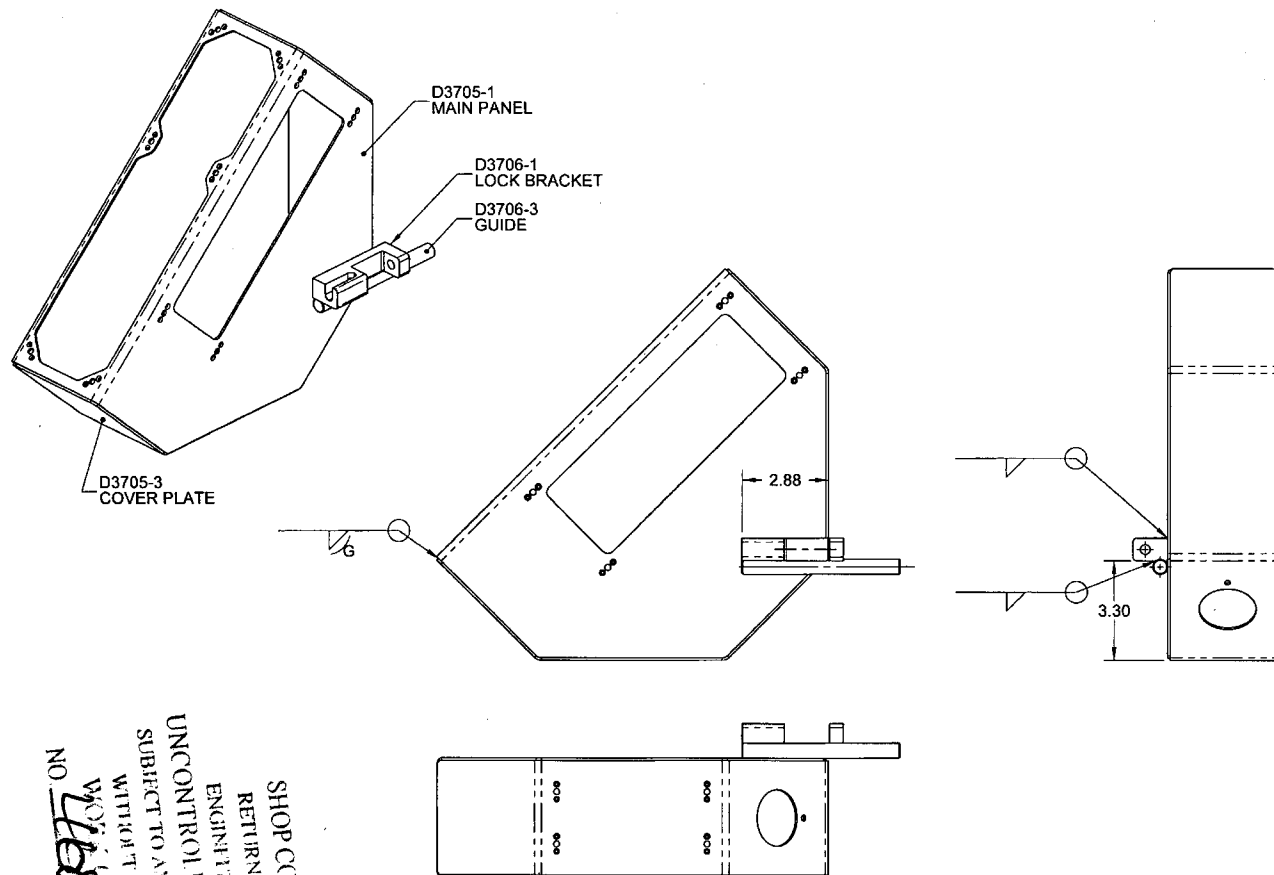


DETAIL B
SCALE 2X

C	ADDED D3705-7/9-11 (SHEET 6); REMOVED MS35589-156 GROMMET; 9.31 AND 12.66 WERE 9.36 AND 12.61 (ZN B6-3); Ø 1.90 WAS 1.50 (ZN D5-4); ADDED Ø 0.204 HOLE (ZN D5-4); CR1122-3-02.5 WAS MS20426AD3-3. REASON: COMPLETED DESIGN OF FACE PLATES REQUIRED TO MOUNT INSTRUMENTS		MB	08.11.20
B	ADDED MS35489-156; QTY 14 MS21075L3 WAS QTY 8; QTY 28 MS20426AD3-3 WAS QTY 16; MS171498 WAS TP-2; AN526C1032R6 WAS MS27039-1-09 & AN960JD101 (ZN D3-1); REDESIGNED D3705-1F FLAT PATTERN (ZN B6-3). REASON: GIVE MORE FLEXIBILITY TO CUSTOMER IN TERMS OF INSTRUMENT ARRANGEMENT		MB	08.08.07
A	NEW ISSUE		MB	08.05.26
REV.		DESCRIPTION	BY	DATE
DESIGN	JL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JL			
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.	DS	D3705	SHEET 1 OF 6	
APPROVED	MPL	TITLE	SCALE	
DE APPR.	TH	INSTRUMENT PANEL ASS'Y	NTS	
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RELEASED
 18/02/05

ITEM	-043 QTY.	P/N	DESCRIPTION
1	X	D3705-043	INSTRUMENT PANEL WELDMENT
3	1	D3705-1	MAIN PANEL
4	1	D3705-3	COVER PLATE
5	1	D3706-1	LOCK BRACKET
6	1	D3706-3	GUIDE



D3705-043 INSTRUMENT PANEL WELDMENT

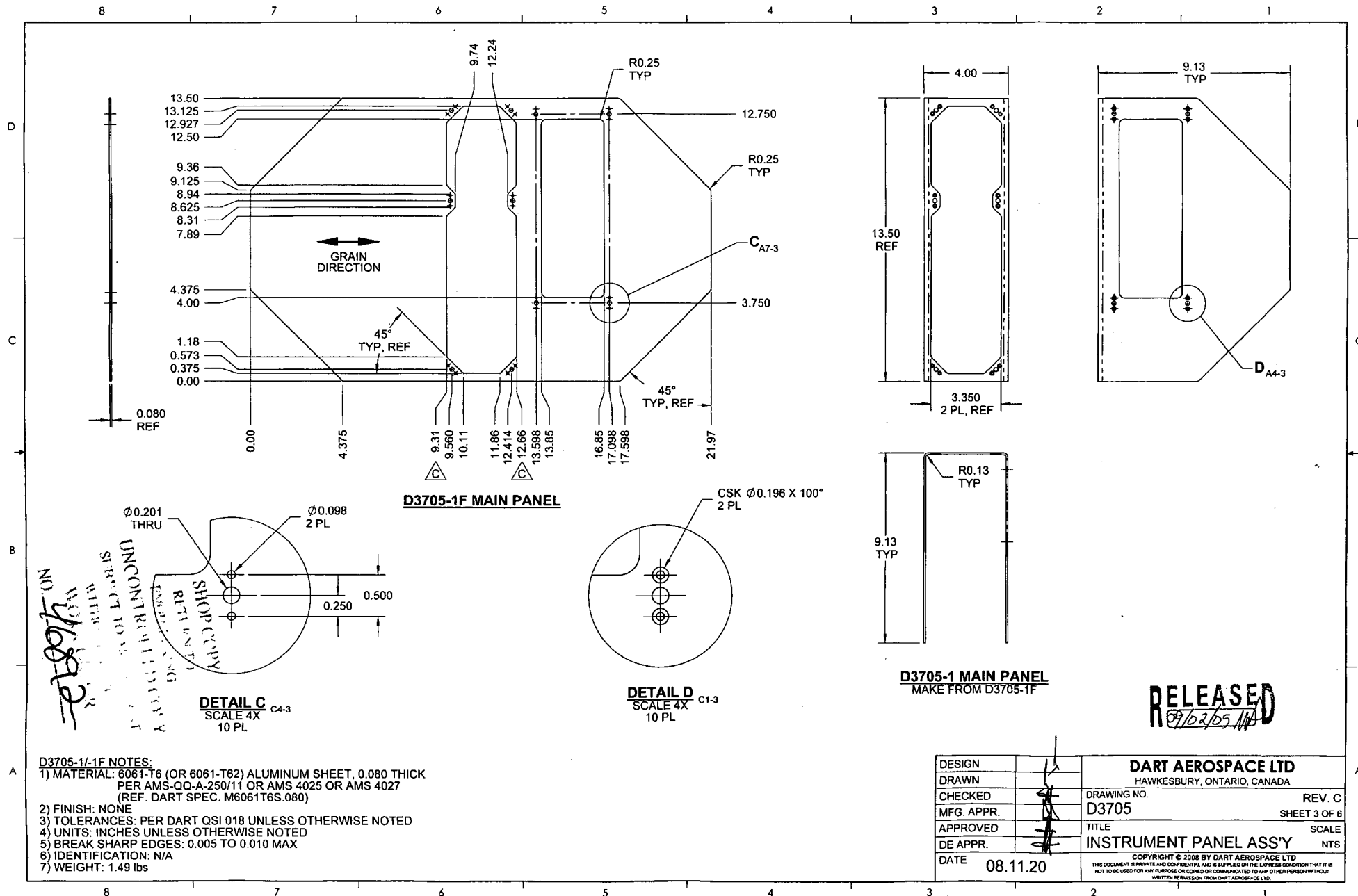
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08/12/05 MJS

D3705-043 NOTES:

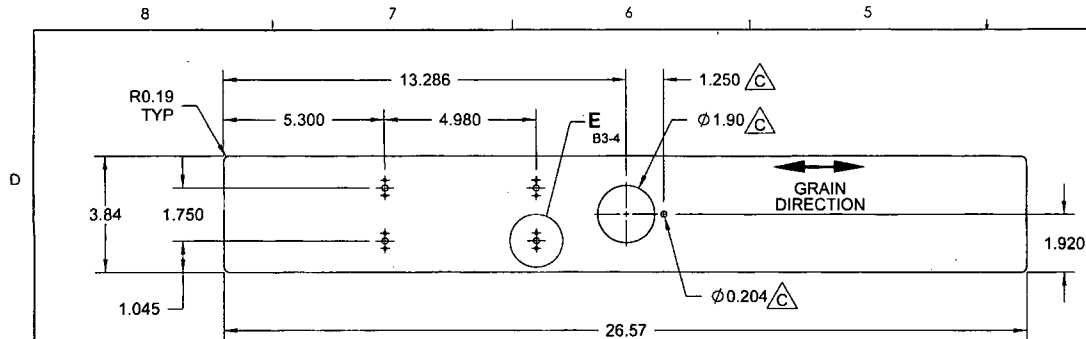
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.90 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3705	SHEET 2 OF 6
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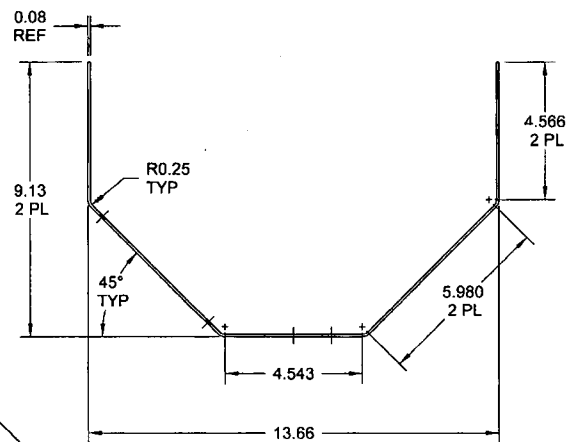
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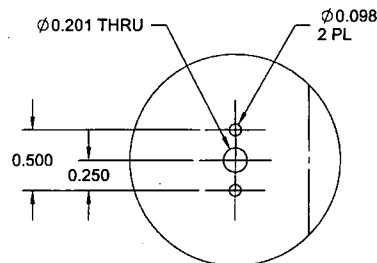
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MFG. APPR.		D3705	SHEET 3 OF 6
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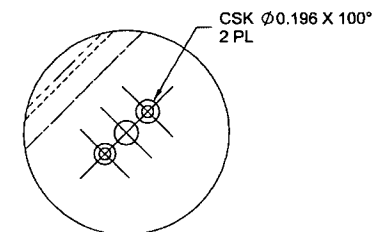
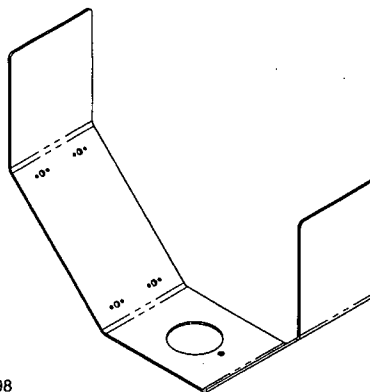
D3705-3F COVER PLATE FLAT PATTERN



**D3705-3 COVER PLATE
(MAKE FROM D3705-3F)**



**DETAIL E
SCALE 4X
D6-4**



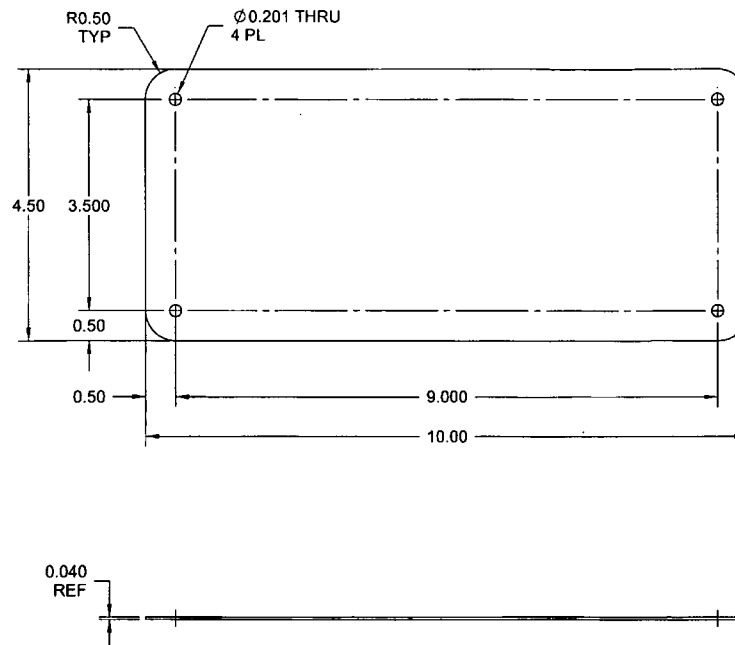
**DETAIL F
SCALE 4X
B8-4**

RELEASED
09/02/05

D3705-3F NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.77 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3705	SHEET 4 OF 8
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D3705-5 ACCESS PANEL

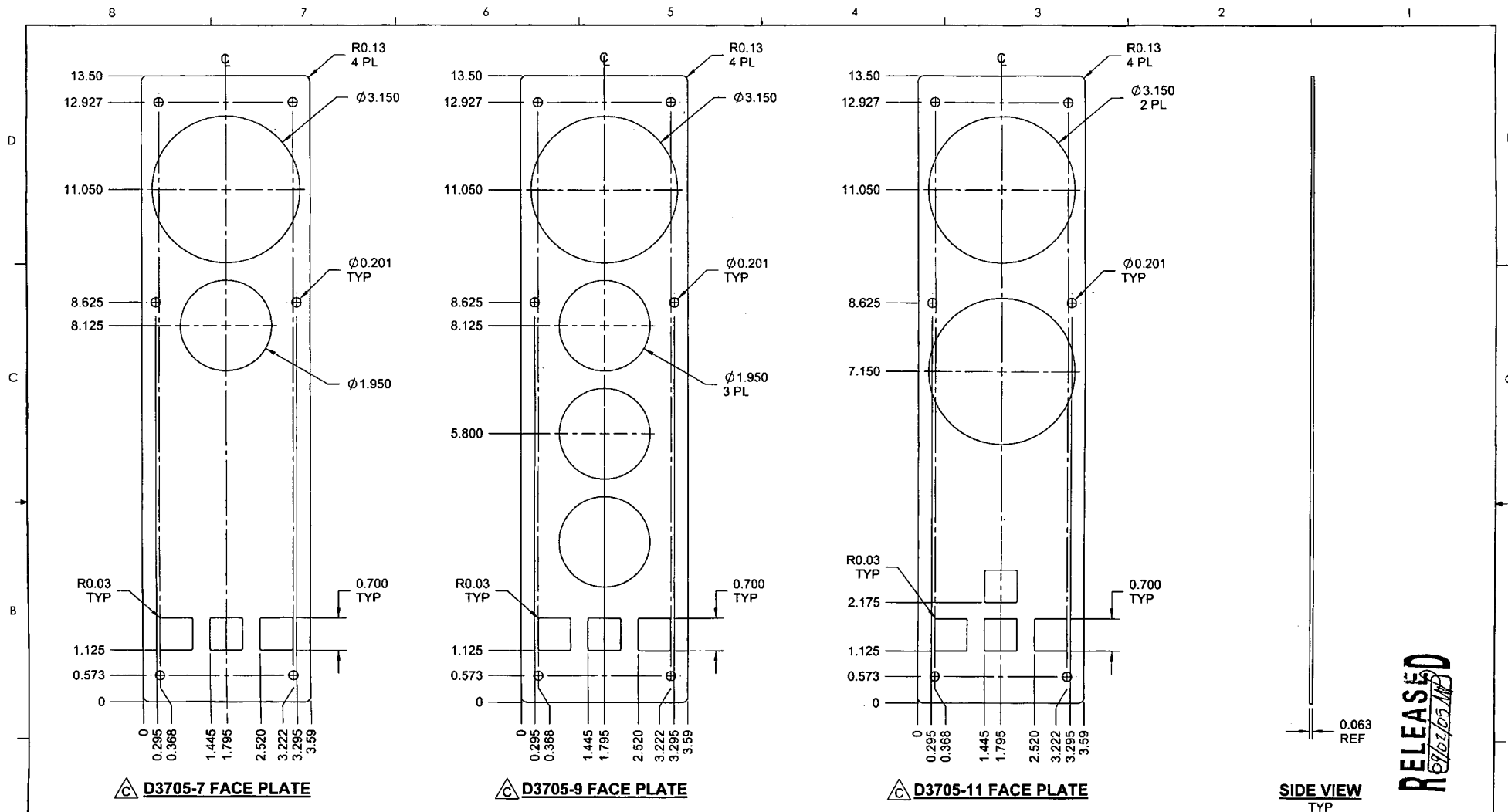
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D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 (REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

RELEASED
 09/02/05 MJD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3705	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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D3705-7/-9/-11 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-X" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: D3705-7 = 0.22 lbs; D3705-9 = 0.18 lbs; D3705-11 = 0.19 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3705 REV. C
MFG. APPR.		SHEET 6 OF 6
APPROVED		TITLE INSTRUMENT PANEL ASS'Y SCALE NTS
DE APPR.		
DATE	08.11.20	

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RELEASED
08/12/15 JHP